

Work Order ID 84318

84318

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May-09-12 1:46:01 PM

Item ID: D3350-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 09/05/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 23/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/05/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3350	Rev A								

100 0.00
100 BAND SAW
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blank: 0.750" x 0.750" x 15.00" long OK/12/05/14 4 0

110 0.00
110 HAAS CNC VERTICAL MACHINING #1
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine D3350-1 as per Folio FA496 and Dwg D3350 Identify as D3350-1 OK/12/05/14 4 0

120 0.00
120 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control OK 12/05/14 4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut Assembly

Stop *NS2*

Start Date: 09/05/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 23/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

0.00

140

Small Fab

0.00

Small Fab

Memo

Small Fab

Tumble and Deburr

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Accept

N900040100

Setup Start

NS1

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Stop

NS2

Item Name: Strut Assembly

Start Date: 09/05/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/05/2012 Req'd Qty: 4.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

4K

12/05/17

170

Small Fab

0.00

170

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3350. Identify as D3350-041 and batch number using a fine point permanent marker

4

0

FF 12-06-29

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

8/7/04/30

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating W121841	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: 11:20 FINISH TIME: 32:00 F OVEN TEMPERATURE: 11:50	0.00 0.00				4X	Ø		M/L 12/07/03
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4	Ø	Ø/B	12/07/03
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: 5 271 Memo	0.00 0.00				4X		SP	12-7-03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/7/4 *[Signature]*
ME
12-07-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84318

84318

Parent Item: D3350-041

D3350-041

Parent Item Name: Strut Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B05.07.11 Powder Coat now done after assembly KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS21042L3 Purchased No

110

Each

2,926.000

2

8

MS21042L3

Nut

**

(4)

FF 12-05-17

Location

Loc Qty

Loc Code

ST300

2926

117885

32

119017

1117

119075

138

121349

656

121444

983

AN3-12A

Purchased

No

170

Each

22.0000

2

8

AN3-12A

Bolt

**

(4)

FF 12-05-17

Location

Loc Qty

Loc Code

ST351

22

114536

1

119641

21

AN960ID10

NAS1149D0363J

Purchased

No

170

Each

0.0000

4

16

AN960ID10

Washer

D2324-5

Manufactured No

170

Each

0.0000

2

8

D2324-5

Strap

**

(4)

FF 12-06-17

07 121243

86 327

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 84318

84318

Parent Item: D3350-041

D3350-041

Parent Item Name: Strut Assembly

Start Date: 09/05/2012

Required Date: 23/05/2012

Start Qty: 4.00

Required Qty: 4.00

M6061T6B0.750X00.75

Purchased

No

170

f

11.2300

1.2604

5.306947

0

M6061T6B0 750X00 750

**

6061-T6 Bar .750 x .750

Location

Loc Qty

Loc Code

MAT002

8.58

114993

4.58

119346

4

MAT003

2.65

119801

2.65

5.307 *mk 12/05/12*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 04318
Description: Strut		Part Number: D3350-1
Inspection Dwg: D3350	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.266	+0.006/-0.001	Ø.267	—		Vernier	
14.88	+/-0.030	14.884	—			
14.500	+/-0.005	14.500	—			
0.375	+/-0.010	374	✓			
1.500	+/-0.005	1.500	—			
0.750	+0.010/-0.000	756	✓			
Ø0.191	+0.005/-0.001	Ø.193	✓			
R0.38	+/-0.030	R.375	—			

Measured by: <i>art</i>	Audited by: <i>26</i>	Prototype Approval: N/A
Date: 12/05/15	Date: 12.5.15	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D3350-041	KJ/JLM	
B	08.07.03	Dimensions and tolerances revised	KJ/DD	
C	08.10.07	R0.38 dimension added	KJ/DD	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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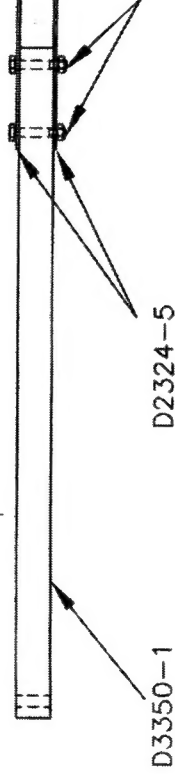
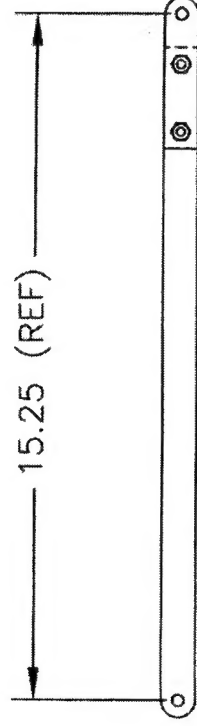
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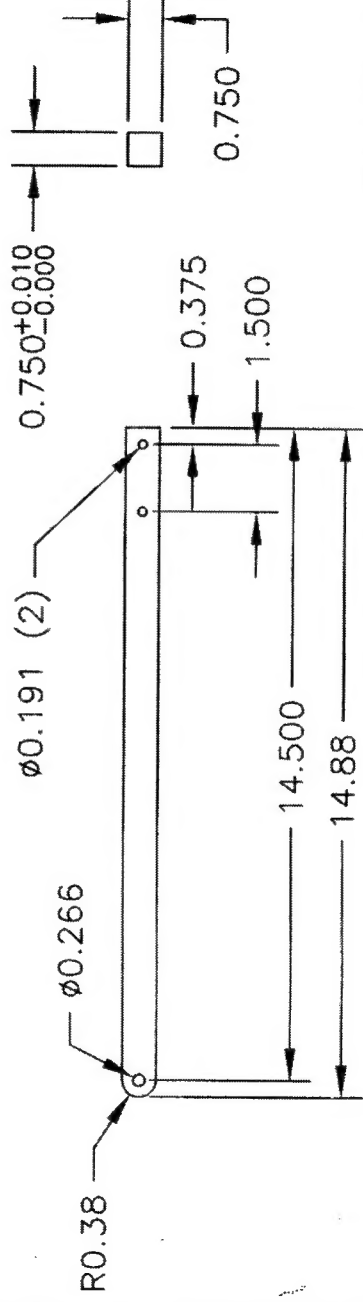
DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED PH	DRAWING NO. D3350
DATE 04.11.12	TITLE STRUT	REV. A SHEET 1 OF 1
04.11.12	SCALE 1:4	



AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(TYP 2 PLACES)

D3350-041 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D3350-041 USING FINE POINT PERMANENT INK MARKER



RELEASED
04.12.16

D3350-1

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3

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